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(71)Applicant : MITSUBISHI PETROCHEM
CO LTD

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(72)Inventor : ISHIZAKI YOSHIHIRO
YAMASHITA TAKASHI

(54) METHOD FOR EXTRUSION LAMINATION OF THERMOPLASTIC RESIN

(57)Abstract:

PURPOSE: To manufacture a laminated article excellent in the bonding strength to a base material by extruding a thermoplastic resin containing an isocyanate compound from the die of an extruder at specific resin temp. to form a molten film and treating the molten film with ozone to bond and laminate the molten film to the base material under pressure using the treated surface as an adhesive surface.

CONSTITUTION: A thermoplastic resin containing an isocyanate compound is extruded from the die of an extruder at resin temp. of 120-350°C to form a molten film. Subsequently, the molten film is treated with ozone to be bonded and laminated to a base material using the treated surface as an adhesive surface. By this method, a laminated article excellent in the bonding strength to the base material can be prepared even when no primer coating treatment is applied to the surface of the base material. When the resin temp. at the time of the extrusion from the die is lower than 120°C, the ductility of the resin becomes inferior and the bonding strength to the base material becomes insufficient. When the resin temp. exceeds 350°C, a problem such as the lowering of heat sealability or the generation of an offensive smell as the laminated article is generated and gelled matter is produced to bring about a problem such as the lowering of mechanical strength or the lowering of appearance.

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